

303 R.750

Work Order ID 85662

June-13-12 12:58:17 PM

85662

Page 1

Item ID: D3403-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop *NS2*

Item Name: Bushing

Start Date: 13/06/2012 Start Qty: 80.00

80

Cust Item ID:

Required Date: 20/06/2012 Req'd Qty: 80.00

80

Customer:

Reference:

Approvals:

Process Plan: HLJDate: 12/06/13

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3403

D

100

0.00

100

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1- Turn as per Folio FA558 & Dwg D3403

Folio Rev: AA Dwg Rev: D

2-Deburr

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85662

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Page 2

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Item ID: D3403-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bushing

Stop ***NS2***

Start Date: 13/06/2012 Start Qty: 80.00

80

Cust Item ID:

Required Date: 20/06/2012 Req'd Qty: 80.00

80

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: ST 42 0.00

130

Packaging

Memo

0.00

Packaging

80x

SP
12-6-19.

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/6/19

ME
12-06-19

W/O:		WORK ORDER CHANGES					
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Picklist Print

June-13-12 12:58:24 PM

Page 1

Work Order ID: 85662

85662

Parent Item: D3403-3

D3403-3

Parent Item Name: Bushing

Start Date: 13/06/2012

Required Date: 20/06/2012

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP Rev:A05.08.31New issueKJ/JLM
IPP Rev:B 06-03-07 As per Rev B JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.750		Purchased		No		100	f	132.5560	0.206	17.34737			

M303R0 750

303 Round Bar 0.750

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT028	132.556	
117328	13.242	
117798	4.004	
118509	4.08	
119346	0.645	
120145	10.566	
121070	1.1	
121157	25.619	
121728	13.3	
→ 122058	60	

17.35 *ent 12/06/18*

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

2.165

2.165

2.165

2.165

2.165

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

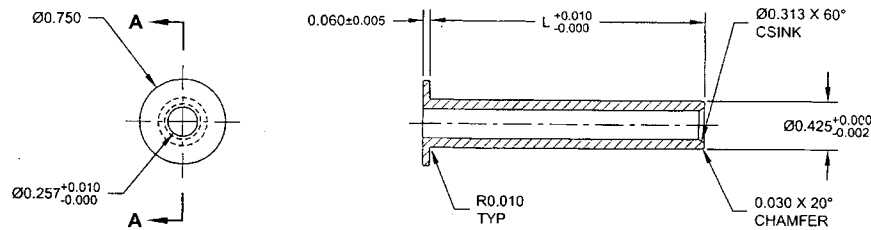
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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25662



SECTION A-A

D3403-X BUSHING

DART P/N	L	WEIGHT (lbs)
D3403-1	2.416	0.07
D3403-3	2.165	0.06
D3403-5	2.440	0.07



RELEASED
2011-10-31
WP

NOTES:

- 1) MATERIAL: AISI 303 SS ROUND BAR
PER ASTM A582
REF. DART SPEC. M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: PER TABLE

D	FOR -5, 2.440 WAS 2.500 (PER PAR 11-125)	XDF	11.10.28
C	REFORMAT TO CURRENT STD PER QSI 043; ADDED D3403-5. TOL WAS +0.005/-0.000. REASON: PAR#10-029	MB	10.04.21
B	ADD COUNTERSINK	PH	06.01.23
A	NEW ISSUE	PH	05.03.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	XDF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.10.28		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. D
D3403 SHEET 1 OF 1
TITLE SCALE
BUSHING NTS

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